



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 63995**

Tuesday, November 23, 2010 9:25:22 AM



Page 3

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 11/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>424</u>	0.00				11/1/17	sp	(12)	
Packaging Packaging	Memo	0.00							
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/01/17

MF

11-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 23, 2010 9:25:26 AM

Page 1

Work Order ID: 63995

Parent Item: D3500-1

Parent Item Name: Saddle




Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013  Saddle Billet		Manufactured	No			100	Each	52.0000	1	12			

Location

Loc Qty

Loc Code

MAT43

52

59467

3

60713

8

61300

1

62010

40

B64278 X12

ml 11/01/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	63925
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490	Vern HL-7	.486	.486	.486	.486		
B	1.175	1.185	"	1.180	1.180	1.180	1.180		
C	3.145	3.155	"	3.150	3.150	3.150	3.150		
D	1.175	1.185	"	1.180	1.180	1.180	1.180		
E	0.365	0.385	"	.365	.375	.375	.375		
F	0.490	0.510	"	.495	.501	.496	.496		
H									
I	R1.575	R1.595	test indicator	1.594	1.596	1.587	1.586		
J	0.240	0.260	Vern HL-7	.240	.245	.252	.252		
K	0.490	0.510	"	.497	.498	.500	.500		
L	3.590	3.650	"	3.610	3.620	3.620	3.620		
M	0.315	0.322	"	.317	.317	.317	.317		
N	0.256	0.262	"	.259	.259	.259	.259		
O	6.500	6.520	Vern CLK-02	6.511	6.511	6.510	6.510		
P	5.990	6.010	"	6.000	6.004	6.003	6.003		
Q	2.820	2.830	Vern HL-7	2.825	2.825	2.825	2.825		
R	2.495	2.505	"	2.500	2.500	2.500	2.500		
S	2.245	2.255	"	2.250	2.250	2.250	2.250		
T	1.120	1.130	"	1.125	1.125	1.125	1.125		
U	0.540	0.560	"	.545	.552	.550	.550		
V	0.793	0.803	"	.798	.798	.798	.798		
W	R.240	R.260	Rol gauge REF	.250	.250	.250	.250		
X	0.040	0.060	Vern HL-7	.045	.060	.060	.055		
Y	0.100	0.120		.107	.120	.117	.116		
AA	R1.125	R1.145	test indicator	1.131	1.140	1.130	1.132		
AB	R.490	R.510	Rol gauge REF	.500	.500	.500	.500		
AC	0.615	0.635	Vern HL-7	.635	.635	.635	.635		
AD	0.240	0.260	Vern HL-7	.250	.245	.255	.252		
AE	1.810	1.830	"	1.823	1.820	1.820	1.820		
AF	0.240	0.260	"	.247	.251	.250	.250		
AG	0.140	0.160	"	.148	.155	.155	.156		
AH	0.140	0.160	"	.158	.158	.160	.160		
AI	0.140	0.160	"	.155	.155	.160	.160		
Accept/Reject									

Measured by:	OML
Date:	11/01/07

Audited by:	CA
Date:	11/1/13

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43995
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.483	0.490		.486	.486	.487	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	0.375		
F	0.490	0.510		.497	.497	.497	0.499		
H									
I	R1.575	R1.595		1.589	1.588	1.588	1.588		
J	0.240	0.260		.252	.253	.253	0.254		
K	0.490	0.510		.500	.500	.499	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	0.317		
N	0.256	0.262		.259	.259	.259	0.259		
O	6.500	6.520		6.511	6.511	6.511	6.510		
P	5.990	6.010		6.004	6.004	6.004	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.551	.552	0.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	0.250		
X	0.040	0.060		.055	.056	.056	0.050		
Y	0.100	0.120		.115	.118	.114	0.110		
AA	R1.125	R1.145		1.135	1.135	1.133	1.134		
AB	R.490	R.510		.500	.500	.500	0.500		
AC	0.615	0.635		.635	.635	.635	0.635		
AD	0.240	0.260		.251	.249	.253	0.253		
AE	.810	1.830		1.823	1.824	1.822	1.822		
AF	0.240	0.260		.253	.252	.253	0.254		
AG	0.140	0.160		.156	.157	.156	.156		
AH	0.140	0.160		.158	.150	.156	0.159		
AI	0.140	0.160		.155	.154	.155	0.156		
Accept/Reject									

Measured by:	OMK
Date:	11/01/07

Audited by:	SA
Date:	11/1/13

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 63925	
<b>Description:</b> Saddle				<b>Part Number:</b> D3500-1	
<b>Inspection Dwg:</b> D3500				<b>Rev:</b> C	
				<b>Page 1 of 1</b>	

				<b>Recorded Actual Dimensions</b>					
<b>Dim</b>	<b>Min</b>	<b>Max</b>	<b>Go/No Go Gauge</b>	<b>#9</b>	<b>#10</b>	<b>#11</b>	<b>#12</b>	<b>By</b>	<b>Date</b>
A	0.483	0.490		0.486	0.486	0.486	0.486	Vern	GA-01
B	1.175	1.185		1.180	1.180	1.180	1.180	"	"
C	3.145	3.155		3.150	3.150	3.150	3.150	"	"
D	1.175	1.185		1.180	1.180	1.180	1.180	"	"
E	0.365	0.385		0.375	0.375	0.375	0.375	"	"
F	0.490	0.510		0.499	0.499	0.499	0.499	"	"
H									
I	R1.575	R1.595		1.587	1.588	1.588	1.588	Dial	HAASZ
J	0.240	0.260		0.253	0.253	0.254	0.253	Vern	GA-01
K	0.490	0.510		0.500	0.500	0.500	0.500	"	"
L	3.590	3.650		3.620	3.620	3.620	3.620	"	"
M	0.315	0.322		0.317	0.317	0.317	0.317	"	"
N	0.256	0.262		0.259	0.259	0.259	0.259	"	"
O	6.500	6.520		6.511	6.511	6.511	6.511	Vern	CNC-02
P	5.990	6.010		6.003	6.003	6.003	6.003	"	"
Q	2.820	2.830		2.825	2.825	2.825	2.825	Vern	GA-01
R	2.495	2.505		2.500	2.500	2.500	2.500	"	"
S	2.245	2.255		2.250	2.250	2.250	2.250	"	"
T	1.120	1.130		1.125	1.125	1.125	1.125	"	"
U	0.540	0.560		0.552	0.553	0.552	0.553	"	"
V	0.793	0.803		0.798	0.798	0.798	0.798	"	"
W	R.240	R.260		0.250	0.250	0.250	0.250	R-6	ref.
X	0.040	0.060		0.050	0.050	0.050	0.050	Vern	GA-01
Y	0.100	0.120		0.110	0.110	0.110	0.110	"	"
AA	R1.125	R1.145		1.135	1.134	1.135	1.135	Dial	HAASZ
AB	R.490	R.510		0.500	0.500	0.500	0.500	R-6	ref.
AC	0.615	0.635		0.635	0.635	0.635	0.635	Vern	GA-01
AD	0.240	0.260		0.255	0.254	0.254	0.255	"	"
AE	1.810	1.830		1.823	1.823	1.823	1.823	"	"
AF	0.240	0.260		0.251	0.251	0.251	0.251	"	"
AG	0.140	0.160		0.154	0.153	0.154	0.154	"	"
AH	0.140	0.160		0.158	0.159	0.159	0.159	"	"
AI	0.140	0.160		0.156	0.157	0.156	0.156	"	"
<b>Accept/Reject</b>									

<b>Measured by:</b> B.A
<b>Date:</b> 11/01/10

<b>Audited by:</b> SA
<b>Date:</b> 11/11/10

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

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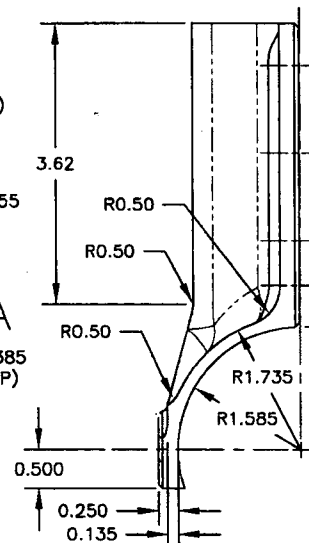
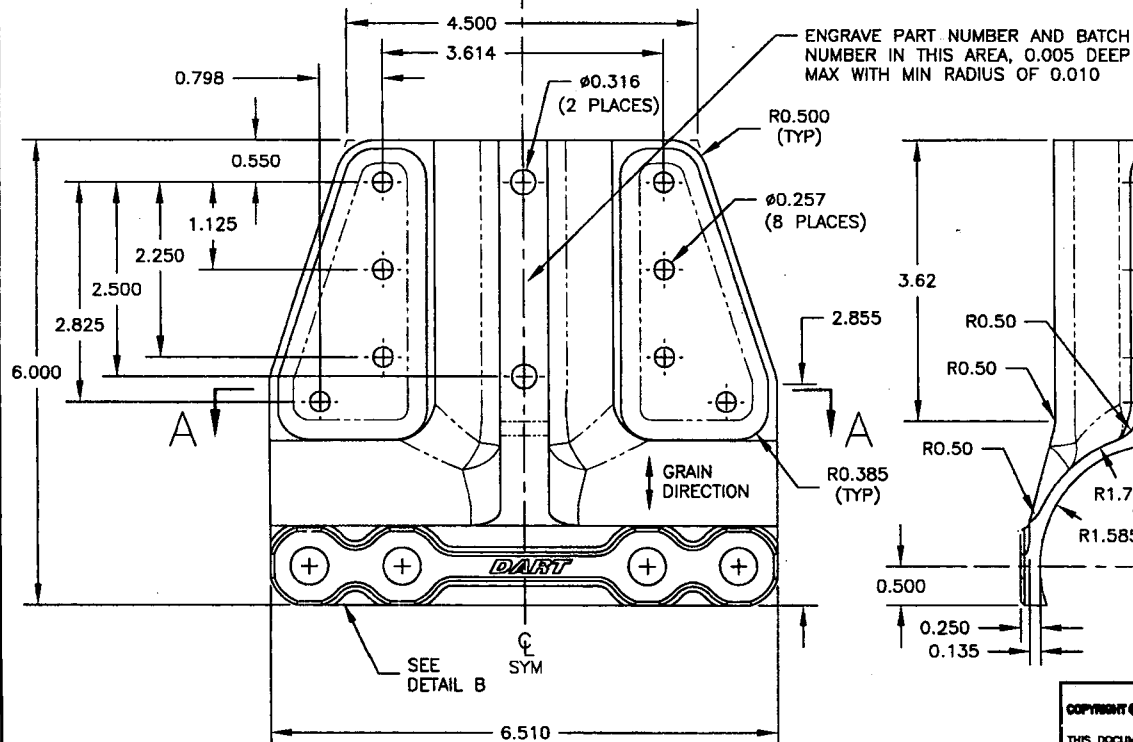
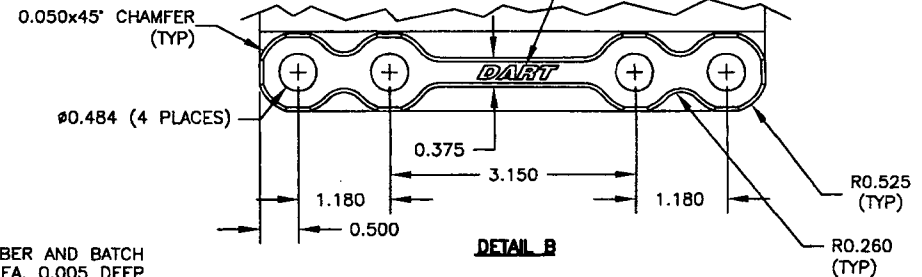
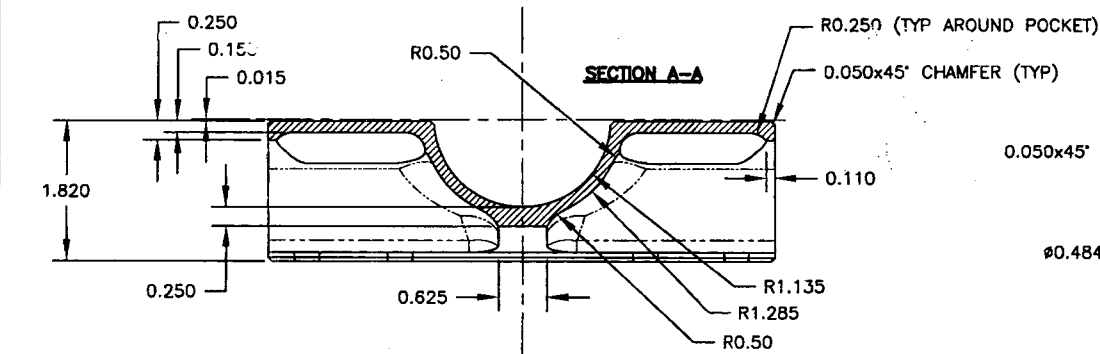
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. *63295*

*PH 10-11-23*

ENGRAVE DART LOGO IN  
THIS AREA TO A MAX  
DEPTH OF 0.015 AND A MIN.  
TOOL RADIUS OF 0.250



### D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)  
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

*06-08-15*

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	<i>GP</i>	DRAWN BY <i>PH</i>
CHECKED	<i>#</i>	APPROVED <i>#</i>
DATE	06.06.30	TITLE
		SADDLE
		SCALE
		2:1

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DART AEROSPACE LTD.

**DART** AEROSPACE LTD.  
WILLOWBURT, ONTARIO, CANADA

REV. C

SHEET 1 OF 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries